

Date: Friday, 7/21/2006 7:37:37 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 28022		
Estimate Number	: 10008		
P.O. Number	: N/A	Part Number	: D2591
This Issue	: 7/21/2006	Drawing Number	: D2591 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 27923	Material	: N/A
Written By	Seq comment below		
Checked & Approved By	JL 06.07.21		
Comment	Est Rev: Removed from 9 Digit 05-10-25 JLM		
Qty: 86 Um: Each			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
	Comment: Qty.: 0.2340 f(s)/Unit Total : 18.7200 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M100283	
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks: 2.700" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
				1			
				1			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/02	3	2 piece pop outside of the vice. Part + scrup.	AB CEP/AB	destroy & replace.	9/1 06/08/02	2	AB CEP/AB 06/08/02	1

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/08/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

84

06/08/01

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

84
06/08/03

Job Completion



Loc6/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28022
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

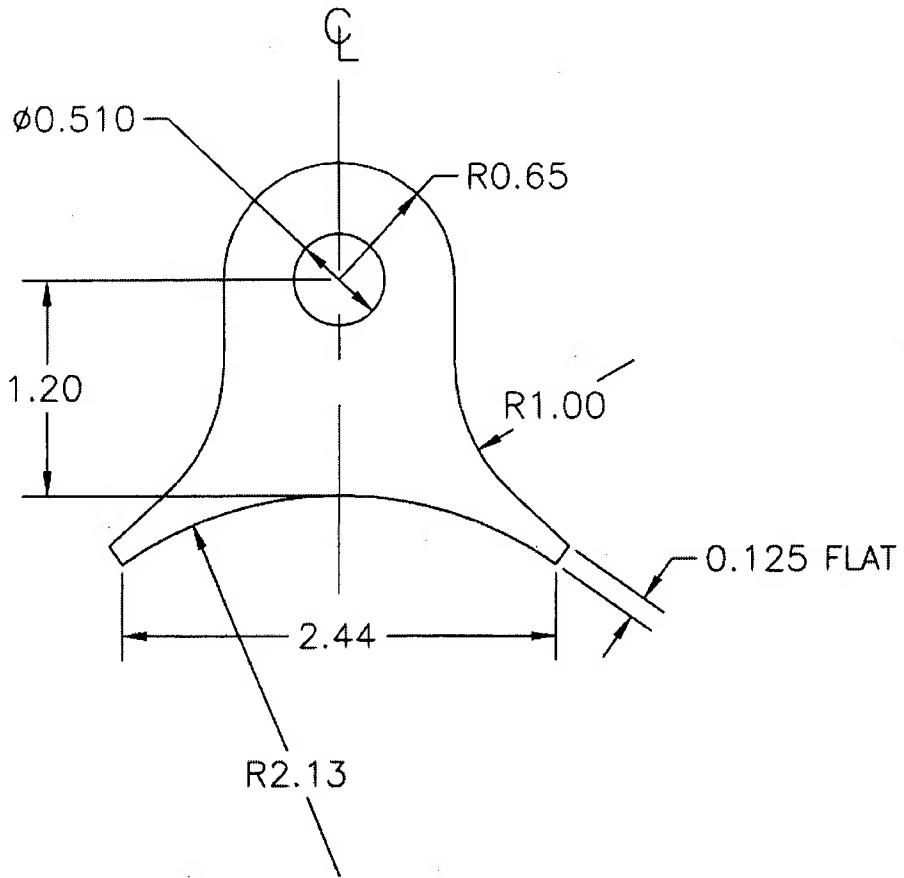
Measured by:	<i>JNL</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	06/07/28	Date:	06/07/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DS1 9161-011	KJ/JLM <i>✓</i>	<i>✓</i>



DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010~~ TO ~~0.020~~

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28022*